

Work Order ID 66008

Tuesday, February 01, 2011 1:16:34 PM

Page 1

Item ID: D3391-025

Accept

Revision ID:

Item Name: Aft Tube Assembly

Start Date: 2/2/2011 Start Qty: 1.00

Required Date: 2/16/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 11-02-01 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3391

Rev H/ DEO

100

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

Turn as per Folio FA599

Rev: AA & Dwg D3391 Rev: H

scribe batch # on fwd end at 90 degree

SL 11/02/08

④

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 11/02/08

111

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

SL 11/02/08

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA 599 Rev: AA & Dwg D3391 Rev: H
2-Debur*and 11/02/10*

130

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

and 11/02/10

140

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*and 11.2.15**(1)*

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803								
160 	BENDING MACHINE - SKIDTUBES	0.00							
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	Form as per Dwg D3391 Using Bend Prog 3391025								
170 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

DP

11-2-23

DP

11-2-23

4.275"

① Ø BE 11/2/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Open Aft cap pilot hole to .208" as per Dwg D3391								
	2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.								
	3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig *****Do Not Open To Finished Size*****								
	4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes.								
	5-Open wearplate holes to 0.250" and c'bore as per dwg D3391								
	6-Open up all wearshoe , wearplate to 0.297"and float bag holes to 0.328" as per Dwg D3391.								
	7-Deburr								

BEU/04/27

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

200

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

0.00



Skidtubes

Skidtubes

Memo

0.00

Instal spacers as per dwg D3391
A/R Magnabond 6398 Batch: *1116678*
exp. date: *08/2011*
cure time 12hrs as per QSI0015*1 2 BB11/04/27*

230

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

*8 11/04/28**1 2*

235

0.00



Pressure Wash per QSI005 4.3

HandFinish

Memo

0.00

AND REALODINE AS PER PAR09-043

1 2 M 11/04/28

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

Required Date: 2/16/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M116964.

Memo

0.00

START TIME: 1:40

OVEN TEMPERATURE: 320°

FINISH TIME: 2:10

1 BR 11-4-28.

250



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

1 φ 221 11-4-29

260



HandFinish

Hand Finishing

HandFinishing

0.00

Memo

0.00

1-Install inserts as per Dwg D3391

2-Install Aft Cap as per Dwg D3391

A/ R Sikaflex-241/-291 M116918.

Sikaflex expiry date: 12-15-01

1 BR 11-4-29.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 66008

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Revision ID:

Stop



Item Name: Aft Tube Assembly

Start Date: 2/2/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/16/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

270

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11 04 29 ①

280

Identify as per dwg & Stock Location: w/o

0.00



Packaging

Memo

0.00

Packaging

D412-742-043/B68643

1 04 29

290

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

04 29 MF
11-04-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Page 1

Tuesday, February 01, 2011 1:16:28 PM

Work Order ID: 66008

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly



Start Date: 2/2/2011

Required Date: 2/16/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev B 06-02-07 ECN773 dwg rev. D EC
 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM □□□□
 IPP rev D 07.03.20 revF dwg EC
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD
 IPP Rev:F 07-11-13 ECN 1056 DD verified by: EC
 IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6014-090 ALUMINUM EXTRUSION		Manufactured	No			100	Each	26.0000	1	1		SL 11/02/08	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				26					
					56572			26					
D3670-4-200 SPACER		Manufactured	No			230	Each	56.0000	4	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				56					
					57349			34					
					63317			22					

BE 4/04/27
 B 67777 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 66008

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 2/2/2011

Required Date: 2/16/2011

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

270 Each

83.0000 1 1



Aft Cap

Location

Loc Qty

Loc Code

FP-4

13

57332

13

FP6

16

52663

3

62678 ✓

12

63633

1

Return 2010

54

62678

54

D3537-1

Manufactured No

270 Each

54.0000 1 1



Wearpad

Location

Loc Qty

Loc Code

FP017

54

64424

54

D3537-7

Manufactured No

270 Each

17.0000 1 1



Wearpad

Location

Loc Qty

Loc Code

FP16

17

56831 ✓

9

65146

8

BR 11-4-29

BR 11-4-29

BR 11-4-29

Tuesday, February 01, 2011 1:16:28 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 2/2/2011

Required Date: 2/16/2011

Start Qty: 1.00

Required Qty: 1.00

D3553-1 Manufactured No

270 Each

29.0000

1 1



Gasket



Location

Loc Qty

Loc Code

FP

29

33868

1

56568 ✓

28

D3553-3 Manufactured No

270 Each

33.0000

1 1



Gasket



Location

Loc Qty

Loc Code

FP

33

53480 ✓

33

D3672-1 Manufactured No

270 Each

1,307.000

2 2



Phenolic Washer



Location

Loc Qty

Loc Code

ST077

1307

42329 ✓

10

52505 ✓

297

64177

1000

BR 11-4-09

BR 11-4-09

2 BR 11-4-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item Name: Aft Tube Assembly



Start Date: 2/2/2011

Required Date: 2/16/2011

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130 Purchased

No

260

Each

729.0000

14

14



Insert

Location

Loc Qty

Loc Code

PKG11

M117331

480

114723

480

ST281

114

116049

114

ST282

96

110511

10

115911

86

ST381

39

114654

39

14 BR 11-4-29.

ALS4-1032-225 Purchased

No

270

Each

4,024.000

12

12



Insert

Location

Loc Qty

Loc Code

PK011

110768 ✓

4024

4024

12 BR 11-4-29.

AN3C4A Purchased

No

270

Each

2,072.000

6

6



BOLT

Location

Loc Qty

Loc Code

ST350

116924.

2072

115300

25

116075

947

116590

100

116704

1000

6 BR 11-4-29

Tuesday, February 01, 2011 1:16:29 PM

Shop Packet Print

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Start Date: 2/2/2011

Required Date: 2/16/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

270

Each

946.0000

4

4



Bolt

Location

Loc Qty

Loc Code

ST350

946

114330

11

115015

13

115371

18

115422

100

115594

6

115835

198

116419 ✓

500

116549

100

4 BR 11-11-09

AN960C10L

NAS1149C0332
R

Purchased

No

270

Each

25.0000

10

10



washer

Location

Loc Qty

Loc Code

ST245

25

107534

25

NAS1149C0332R

m 117091

10 BR 11-11-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DART AEROSPACE LTD		Work Order: 66008
Description: Float Skidtube (412)		Part-Number: D3391-3
Inspection Dwg: D3391	Rev: H	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.00	✓		m-tape	
3.500	+/-0.010	3.502	✓		Vern. JL-3	
88.93	+/-0.030	88.920	✓		m-tape	
44.995	+/-0.030	44.965	✓		m-tape	
Ø3.200	+/-0.010	3.203	✓		mic CNC-05	
88.93	+/-0.030	88.937	✓		m-tape	
Ø3.750	+/-0.010	3.747	✓		Vern. JL-3	
30° x 160" chamfer	+/-0.010	30° x 160"	✓			

Measured by: *DL* **Date:** 11/02/08

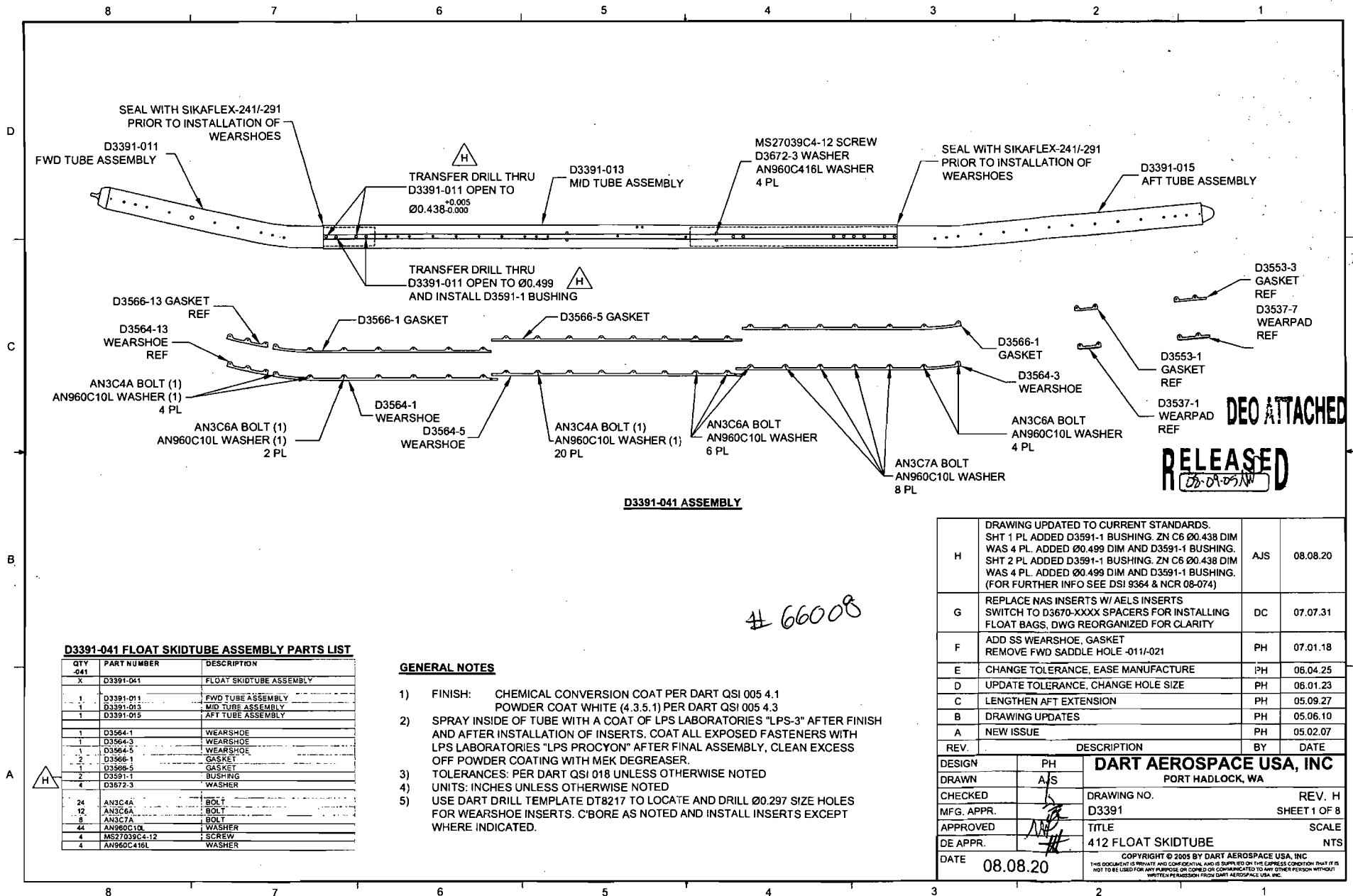
Audited by: *cmf* **Date:** 11/02/08

HAAS Section						
1.526	+0.000/-0.030	1.520	—		Vern	ML-7
7.500	+/-0.010	7.498	—		Vern	CNC-02
27.750	+/-0.010	27.750	—		M-tape	ML-2
31.750	+/-0.010	31.750	—		"	"
35.250	+/-0.010	35.250	—		"	"
3.300	+/-0.010	3.306	—		Vern	LX-02
0.200	+/-0.010	.200	—		"	"
3.520	+/-0.010	3.524	—		Micro	JLM-4
0.687	+0.010/-0.000	.688	—		Vern	ML-7
R0.062	+/-0.010	R.062	—		Red-gay	
Ø0.484	+0.005/-0.001	Ø.486	—		Vern Vern	ML-7

Measured by: *cmf* **Date:** 11/02/10

Audited by: *DL* **Date:** 11-2-15

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	



D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

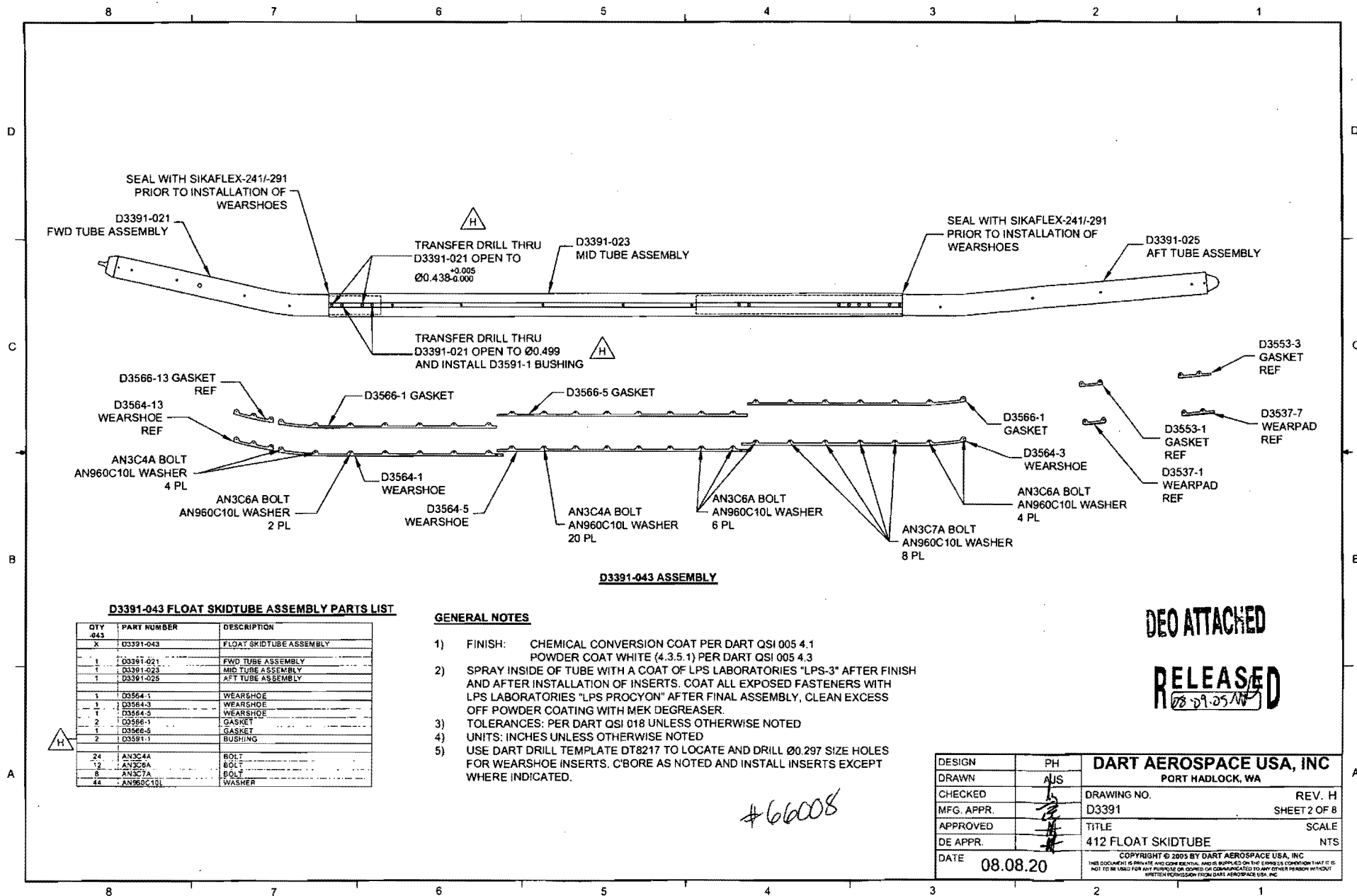
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

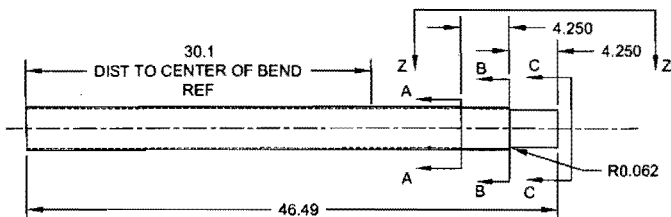
66008

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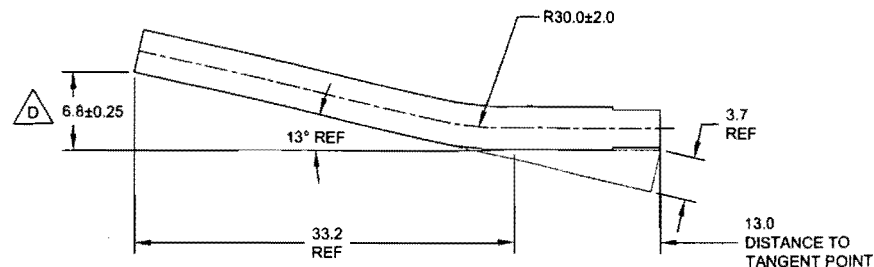
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H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.08.20		
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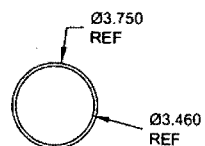




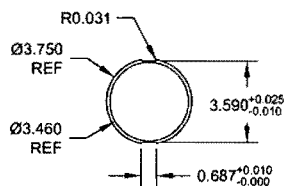
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



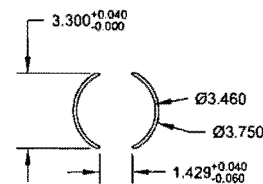
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



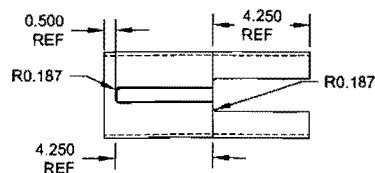
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X

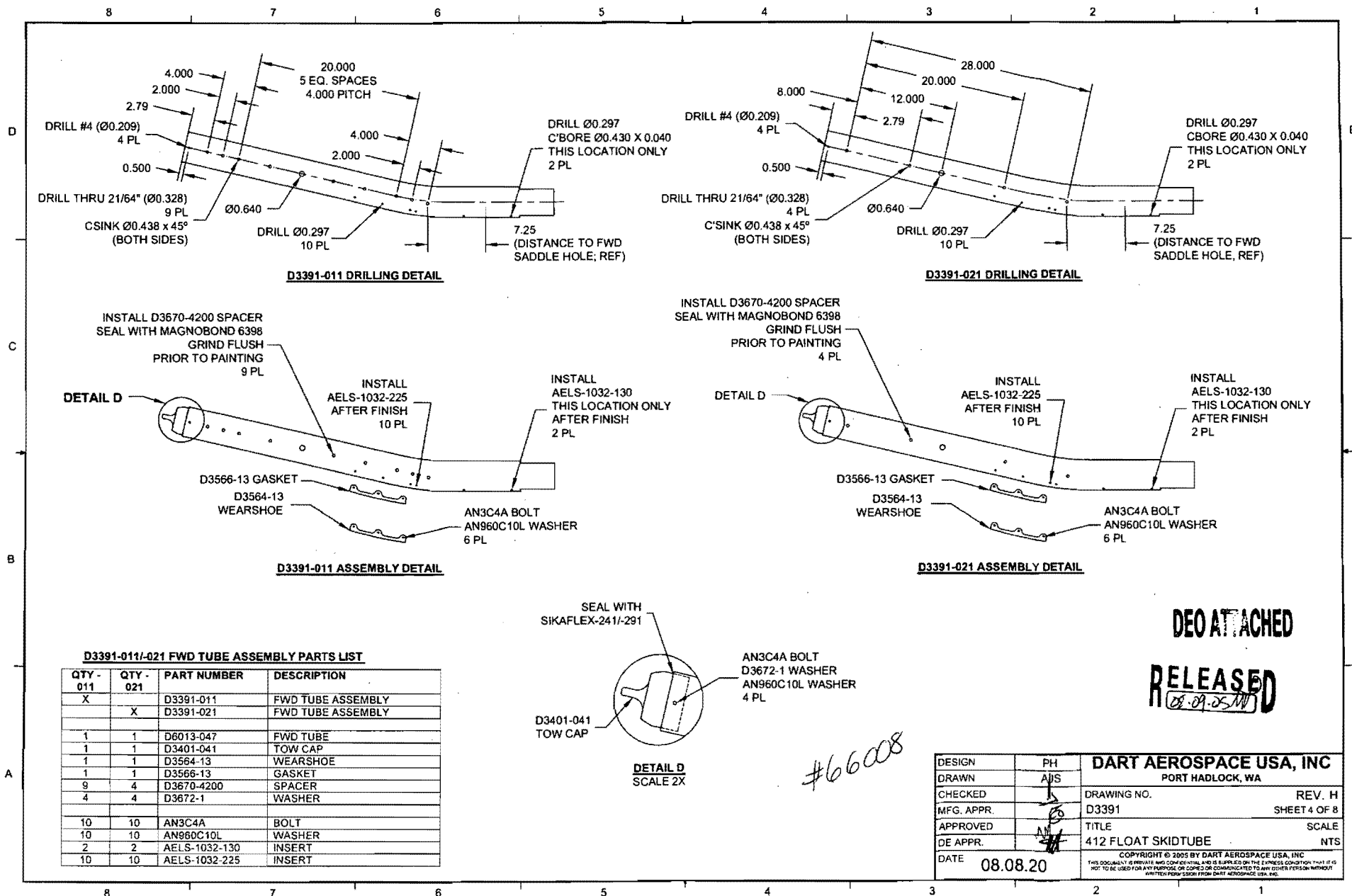


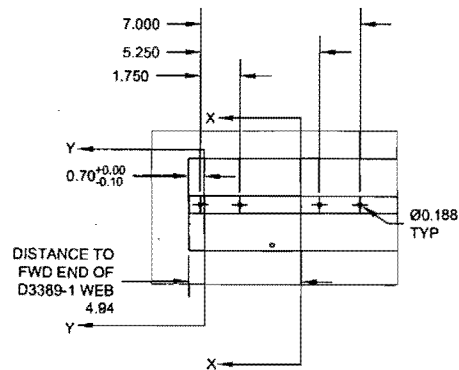
VIEW Z-Z
SCALE 2X

#66008

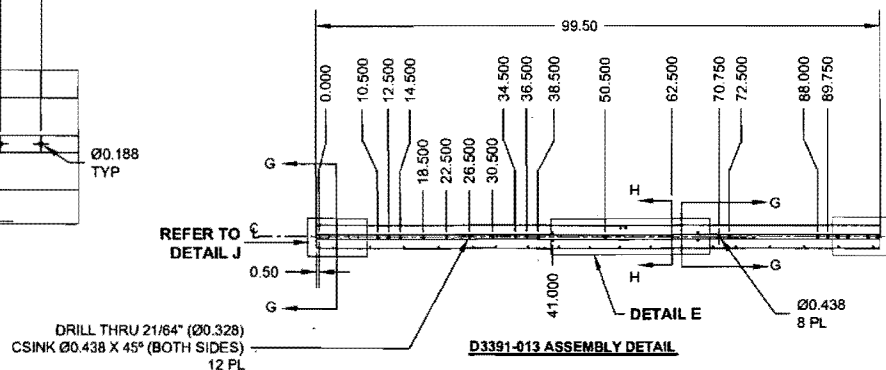
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MFG. APPR.	GO	D3391	SHEET 3 OF 8
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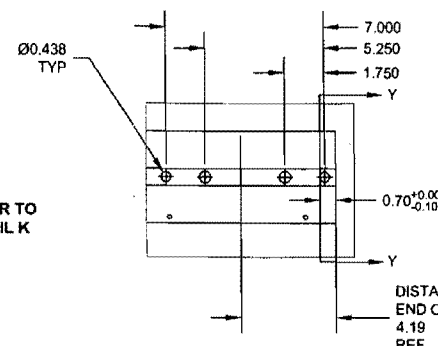




DETAIL J
SCALE 4X



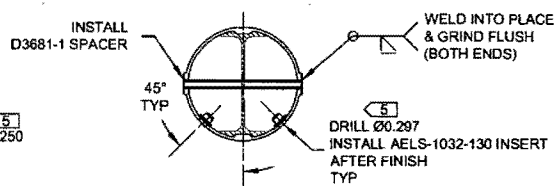
D3391-013 ASSEMBLY DETAIL



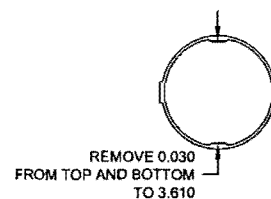
DETAIL K
SCALE 4X



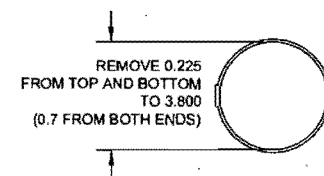
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



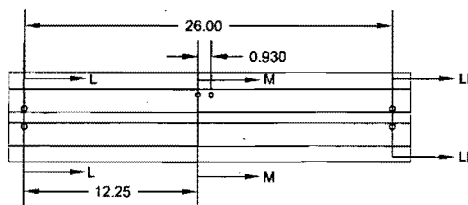
SECTION X-X
SCALE 5X



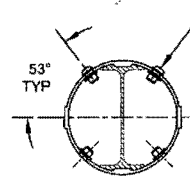
SECTION Y-Y
SCALE 5X

D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
-013		
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

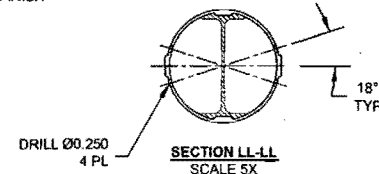


DETAIL E
SCALE NONE

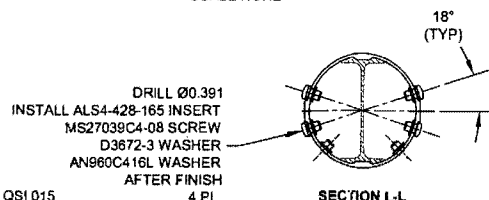


SECTION M-M
SCALE 5X

DRILL Ø0.297
INSTALL AELS-1032-130 INSERT
MS27039C1-09 SCREW
D3672-1 WASHER
AN960C10L WASHER
AFTER FINISH
4 PL



SECTION LL-LL
SCALE 5X



SECTION L-L
SCALE 5X

D3391-013 MID TUBE ASSEMBLY

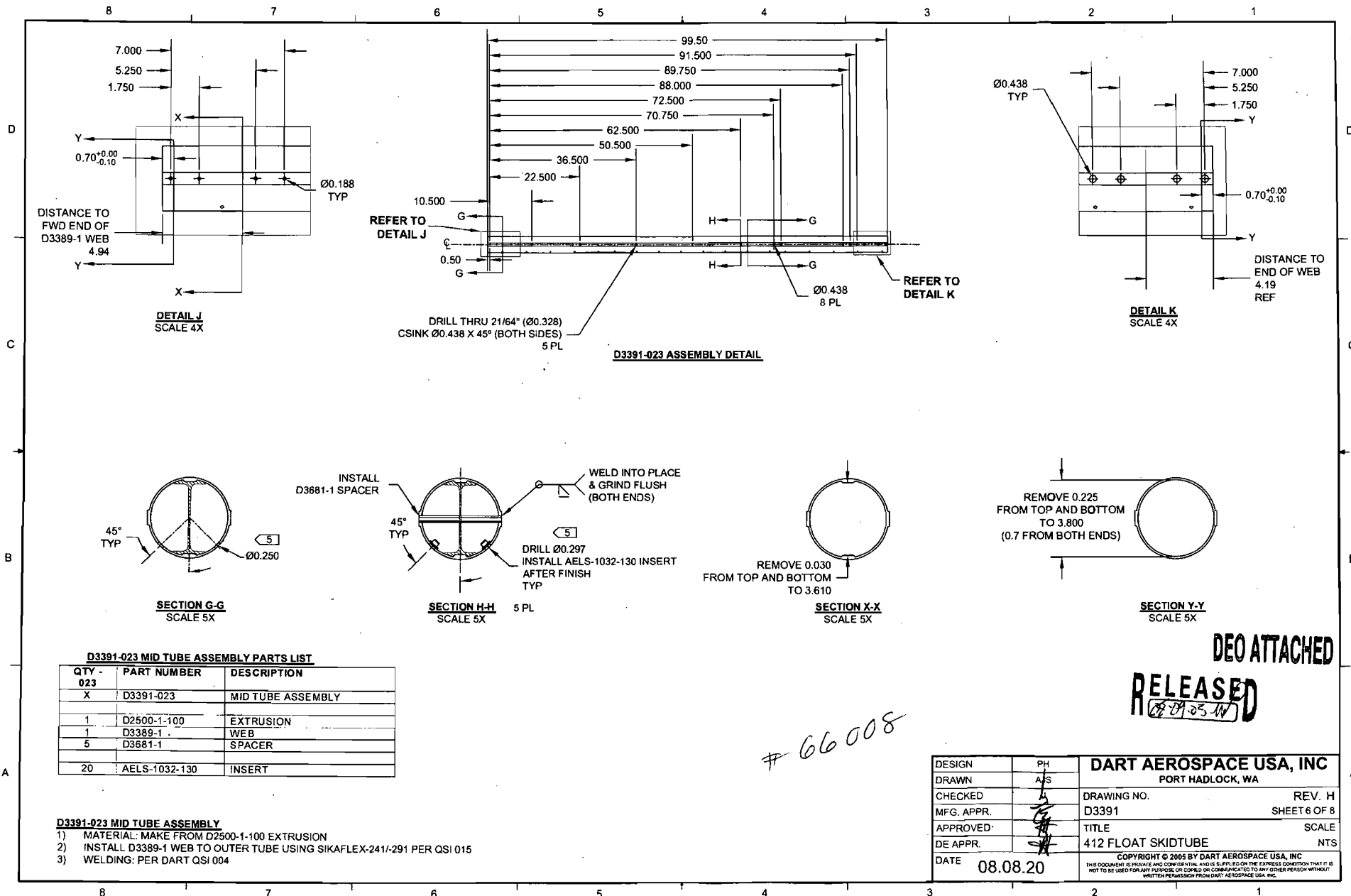
- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- WELDING: PER DART QSI 004

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MFG. APPR.		D3391	SHEETS 5 OF 8
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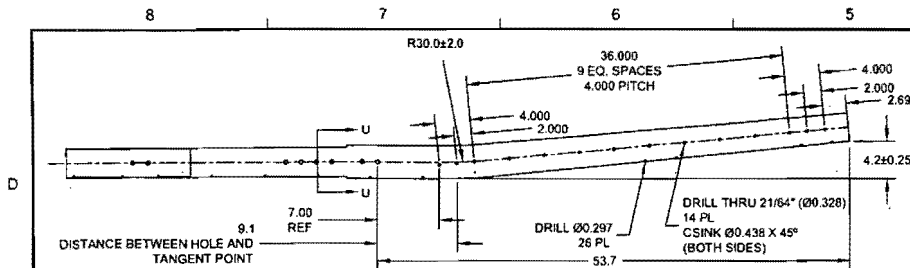
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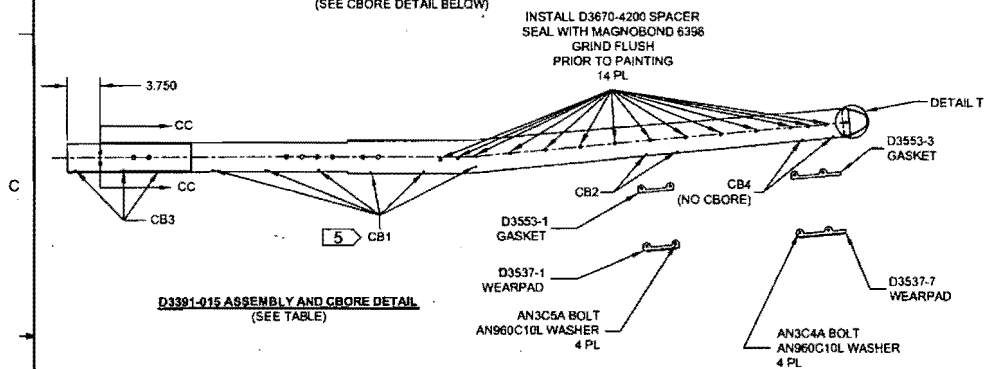
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08-09-05 W

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D3391-015 BENDING AND DRILLING DETAIL
(SEE CBORE DETAIL BELOW)



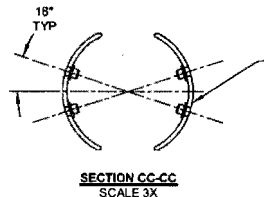
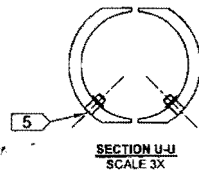
D3391-015 ASSEMBLY AND CBORE DETAIL
(SEE TABLE)

D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

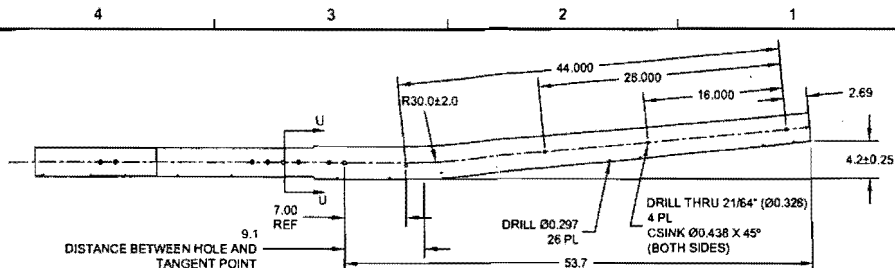
QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X		D3391-015	AFT TUBE ASSEMBLY
	X	D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
14	14	AELS-1032-130	INSERT
12	12	AELS-1032-225	INSERT
4		ALS4-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER

CBORE HOLES MARKED CB1-CB4 AS FOLLOWS AND
INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

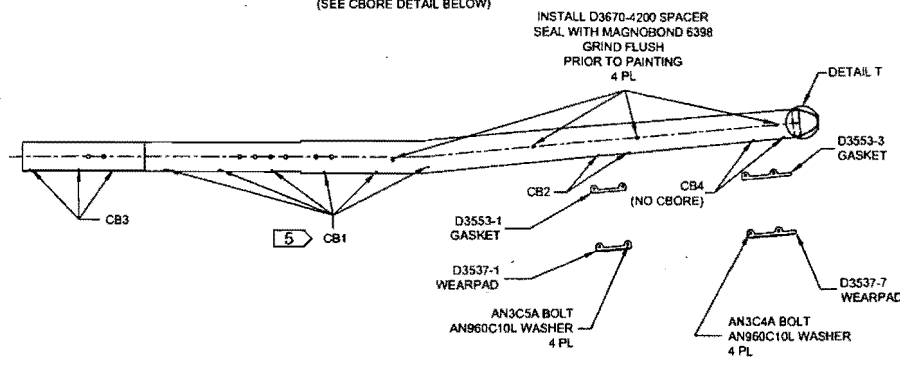
HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	P/N
CB1	12	12	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130



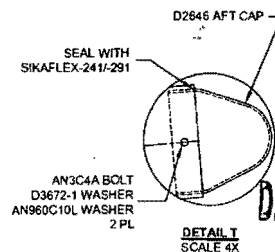
DRILL Ø0.391
CBORE Ø0.516 X 0.040 DEEP
INSTALL ALS4-428-165 INSERT
4 PL



D3391-025 BENDING AND DRILLING DETAIL
(SEE CBORE DETAIL BELOW)



D3391-025 ASSEMBLY AND CBORE DETAIL
(SEE TABLE)



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08-09-05/10

#66008

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DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>h</i>	MFG. APPR. <i>AA</i>	APPROVED <i>MP</i>		DE APPR. <i>h</i>		
DATE 09.09.23	DATE 04.04.24	DATE 09/09/25	DATE 09/09/30		DATE 09/09/30		

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH~~
~~AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH~~
 LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
 OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
 2010-02-02

MP

#66008

